



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D5468-1

Job Sheet 198588



Part No: D5468-1

Job Qty: 8 pcs

Part Name: Saddle, Aft, Out



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/31/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 9/9/19

Description:

Note: IPP Rev.A 17.07.12 New issue DP Verify DD IPP REV:B 17.11.03 AS PER DWG REV.A DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
90	Machining - Issue SN	8 pcs	9/9/19		0.00	0.00	HAAS - 1			
							HAAS - 2			
							HAAS - 3			SBL 19/08/19
							HAAS - 4			
100	HAAS 4 Axis - B4B	8 pcs	9/9/19		3.00	15.85	HAAS - 1 - B4B			
							HAAS - 2 - B4B			
							HAAS - 3 - B4B			SBL 19/08/19
							HAAS - 4 - B4B			
120	QC 2	8 pcs	9/9/19		0.00	0.00	QC 2 - 1			
							QC 2 - 12			
							QC 2 - 14			
							QC 2 - 17			
							QC 2 - 19			
							QC 2 - 2			
							QC 2 - 20			
							QC 2 - 22			
							QC 2 - 23			
							QC 2 - 25			
							QC 2 - 32			
							QC 2 - 33			
							QC 2 - 35			
							QC 2 - 39			
							QC 2 - 4			
							QC 2 - 40			
							QC 2 - 44			
							QC 2 - 45			
							QC 2 - 48			
							QC 2 - 49			
							QC 2 - 50			
							QC 2 - 51			
							QC 2 - 52			



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Container No: S229037



Part: D5468-1

Job No: 198588

Serial No/Batch: S229037

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 9/01/19

130 QC 8	8 pcs	9/9/19	0.00	0.00	QC 2 - 57	SBL 19/11/06
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
140 Handfinish - 1-1 Chemical-B4B	8 pcs	9/9/19	0.00	1.12	QC 8 - 39	SBL 19/11/07
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 -	

						B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
150 Spray Paint - 2 - B4B	8 pcs	9/9/19	0.00	0.20		Spray Paint - 1 - B4B	
						Spray Paint - 2 - B4B	RD 19-11-11
						Spray Paint - 3 - B4B	
						Spray Paint - 4 - B4B	
160 QC 14	8 pcs	9/9/19	0.00	0.00		QC 14 - 15	
						QC 14 - 2	
						QC 14 - 34	
						QC 14 - 41	
						QC 14 - 51	
						QC 14 - 58	
						QC 14 - 59	
						QC 14 - 9	
						QC 14 - 68	
						QC 14 - 40	NOV 14 2019 DAS 40 8-8
						QC 14 - 19	
						QC 14 - 43	
						QC 14 - 24	
						QC 14 - 61	
						QC 14 - 81	
170 Packaging 3-1 - Stock - B4B	8 pcs ✓	9/9/19	0.00	0.00		Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B ✓	ST399
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	

Oscar

NOV 14 2019

				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	8 pcs	9/9/19	0.00 0.00	QC 21 - SA - 21 ✓	52399
				QC 21 - SA - 70	21
				QC 21 - SA - 53	NOV 14 2019

Part Op 100 - (HAAS CNC Vertical Machine) Program Batch No 5229037 Double check by: SL 1-Machine Step No 1 per
 Descriptions: Folio FB548 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FB548 and inspect per attached
 Dimension Sheets 3-Machine Step No 3 per Folio FB548 and insp
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (Spray Paint / NDT Room) ***MASK HOLES PRIOR TO PRIME AND PAINT AS PER DWG NOTE 9*** 1-PRIME AS
 PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: 5200299 2-PAINT AS PER DWG AND QSI005 4.2.2.4
 PAINT BATCH: 5219125
 160 - (QC14- Inspect Spray Paint)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D6101-007	Saddle Billet	8 pcs (1 ea)	90-Machining - Issue SN	<u>5204067</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Machining - Issue SN	D6101-007	8	21	0

Part Specifications
Specifications could not be found.

Plex 7/31/19 7:53 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	198588
Description: Saddle, Aft Outboard		Part Number:	D5468-1
Inspection Dwg: D5469 Rev. A		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D5469 Rev. A and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	0.438	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.998	7.997	7.997	7.997		
F	0.490	0.510		0.503	0.503	0.502	0.501		
G	0.257	0.262		0.257	0.257	0.257	0.257		
H	0.375	0.380		0.385	0.375	0.375	0.375		
I	0.490	0.510		0.5005	0.499	0.500	0.500		
J	1.174	1.184		1.180	1.180	1.180	1.179		
K	0.558	0.578		0.565	0.567	0.568	0.568		
L	1.174	1.184		1.180	1.180	1.180	1.179		
M	1.365	1.375		1.369	1.369	1.369	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.135	0.132	0.135	0.132		
Q	0.115	0.135		0.125	0.125	0.125	0.125		
R	0.240	0.260		0.250	0.251	0.251	0.251		
S	0.115	0.135		0.128	0.127	0.128	0.128		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.231	3.231	3.231	3.230		
V	0.230	0.250		0.238	0.238	0.238	0.237		
W	0.115	0.135		0.132	0.130	0.129	0.130		
X	0.352	0.372		0.365	0.364	0.365	0.362		
Y	0.470	0.530		0.500	0.500	0.500	0.500		
Z	0.615	0.635		0.628	0.625	0.624	0.627		
AA	0.053	0.073		0.060	0.063	0.063	0.063		
AB	0.240	0.260		0.250	0.250	0.250	0.248		
AC	1.500	1.520		1.510	1.510	1.510	1.510		
AD	0.115	0.135		0.130	0.135	0.135	0.135		
AE	0.240	0.280		0.260	0.260	0.260	0.260		
AF	0.240	0.260		0.258	0.250	0.250	0.250		
AG	2.000	2.020		2.000	2.000	2.000	2.000		
Accept/Reject									

Measured by:	W/S
Date:	19/11/14 / 19/11/05

Audited by:	mmc
Date:	19/11/07

Rev	Date	Change	Revised by	Approved
A	18.05.30	New Issue	MG	

DART AEROSPACE LTD	Work Order:	198588
Description: Saddle, Aft Outboard	Part Number:	D5468-1
Inspection Dwg: D5469 Rev. A		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D5469 Rev. A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	26	37	48	By	Date
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.997	7.997	7.997	7.997		
F	0.490	0.510		.502	.503	.503	.503		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.500	.501	.500	.500		
J	1.174	1.184		1.174	1.174	1.174	1.174		
K	0.558	0.578		.569	.569	.567	.569		
L	1.174	1.184		1.174	1.174	1.174	1.174		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		.132	.132	.133	.132		
Q	0.115	0.135		.125	.125	.125	.125		
R	0.240	0.260		.251	.250	.250	.250		
S	0.115	0.135		.127	.126	.125	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.230	3.230	3.230	3.230		
V	0.230	0.250		.237	.238	.238	.238		
W	0.115	0.135		.130	.130	.131	.131		
X	0.352	0.372		.365	.366	.365	.365		
Y	0.470	0.530		.500	.500	.500	.500		
Z	0.615	0.635		.624	.624	.625	.624		
AA	0.053	0.073		.065	.063	.063	.063		
AB	0.240	0.260		.248	.248	.249	.249		
AC	1.500	1.520		1.510	1.510	1.510	1.510		
AD	0.115	0.135		.120	.120	.120	.122		
AE	0.240	0.280		.260	.260	.260	.260		
AF	0.240	0.260		.250	.251	.252	.250		
AG	2.000	2.020		2.000	2.000	2.000	2.000		
Accept/Reject									

Measured by: SBL
Date: 19/11/06

Audited by: [Signature]
Date: 19/11/07

Rev	Date	Change	Revised by	Approved
A	18.05.30	New Issue	MG [Signature]	[Signature]

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐				DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐				MRB (QSI042)																													
Date: _____		Sequence #: _____		QTY Affected: _____		Disposition																																	
Description Work Order Deviation						Completed By																																	
						Lead hand / Supervisor																																	
						QC / QA Coordinator																																	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐						FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>						Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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Other/Details: _____																																							